

Date: Wednesday, 13/09/2006 1:56:44 PM
User: COSS Admin

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CABLE GUARD
Job Number : 28503	
Estimate Number : 12410	
P.O. Number : <i>N/A</i>	Part Number : D34993
This Issue : 13/09/2006 S.O. No. : <i>N/A</i>	Drawing Number : D3499 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : B
Previous Run : 28303	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 20/09/2006 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev:A New Issue 06-05-05 JLM Est Rev:B As per Rev B 06-08-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MUHMWB625	UHMW .625 Black Tivar 1000
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Comment: Qty.: 1.1351 sf(s)/Unit Total : 6.8103 sf(s)
UHMW .625 Black Tivar 1000
Batch: *M101046* *ml 06 09 13*

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
1-Cut as per Dwg D3499
Dwg Rev: *B*
Prog Rev: *B*

ml 06 09 13

(6)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 11 29

(6)

4.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

1- Mill as per Folio FA636 Rev: *A* & Dwg D3499 Rev: *B*

2-Deburr per dwg D3499

J.F. 06/12/04

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/12/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 13/09/2006 1:56:44 PM
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Drawing Name: CABLE GUARD

Job Number: 28503

Part Number: D34993

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

06/12/04

(6)

6.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE
C'BORE AS PER DWG D3499

J.F. / DSP 06/12/16

7.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / DSP 06/12/16

8.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.E. 06/12/18

(6)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: _____

ML 06/12/16

(6)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

06/12/19

(2)

Job Completion



C Log 06/12/12

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

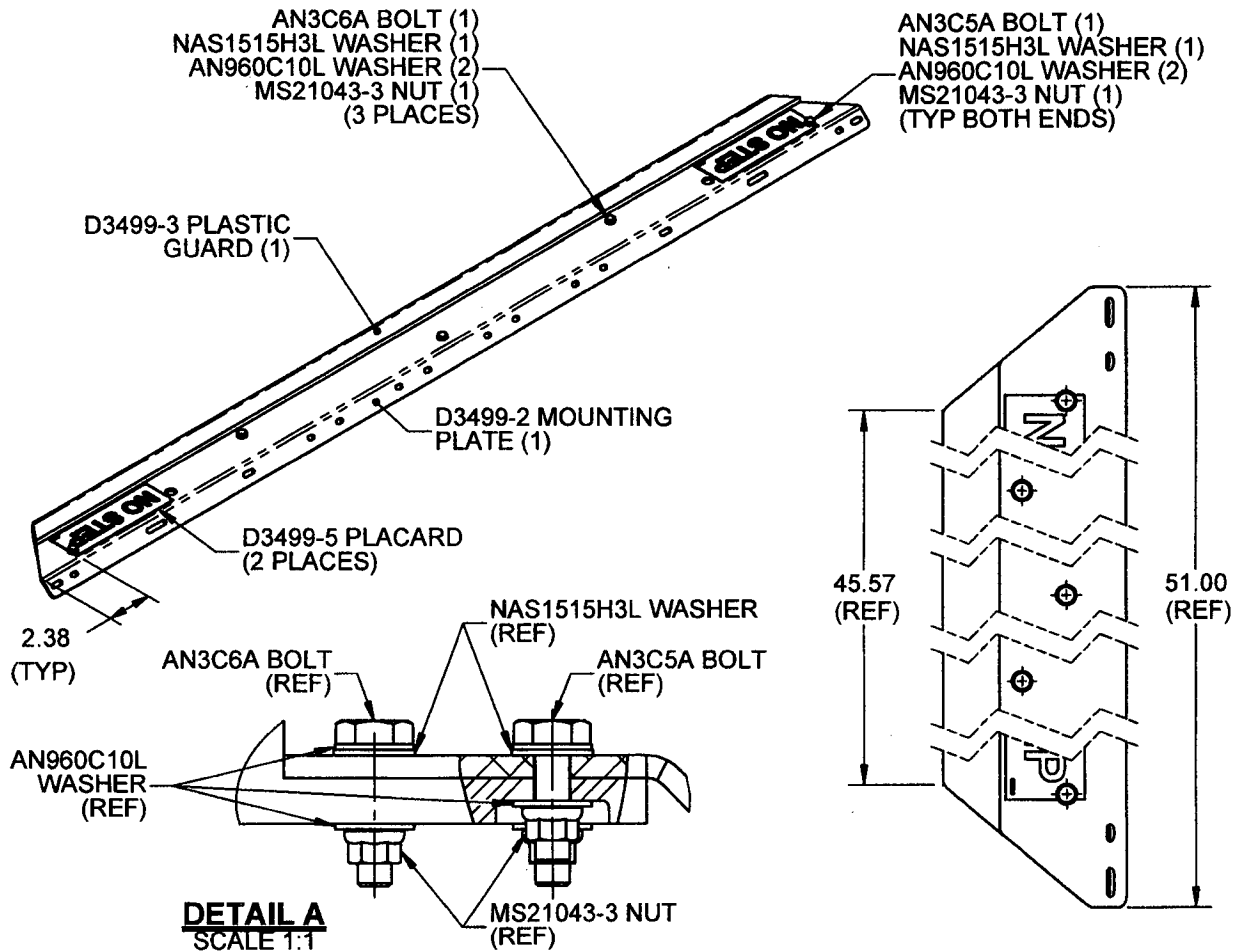
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

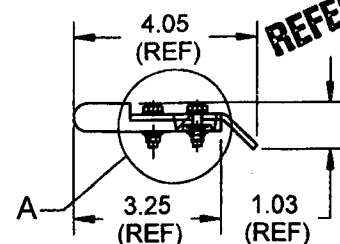
NOTE: Date & initial all entries

DART

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 1 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4
A	06.04.11	NEW ISSUE	
B	06.08.15	RE-DESIGN D3499-2F/-3	

**D3499-042 CABLE GUARD ASSEMBLY**

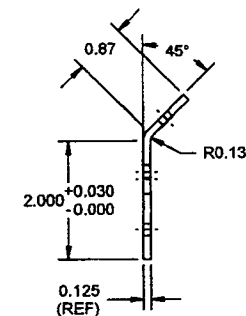
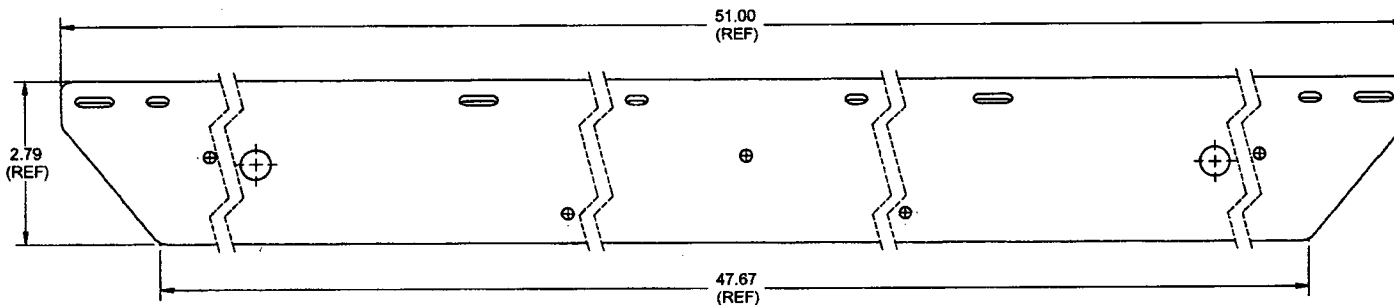
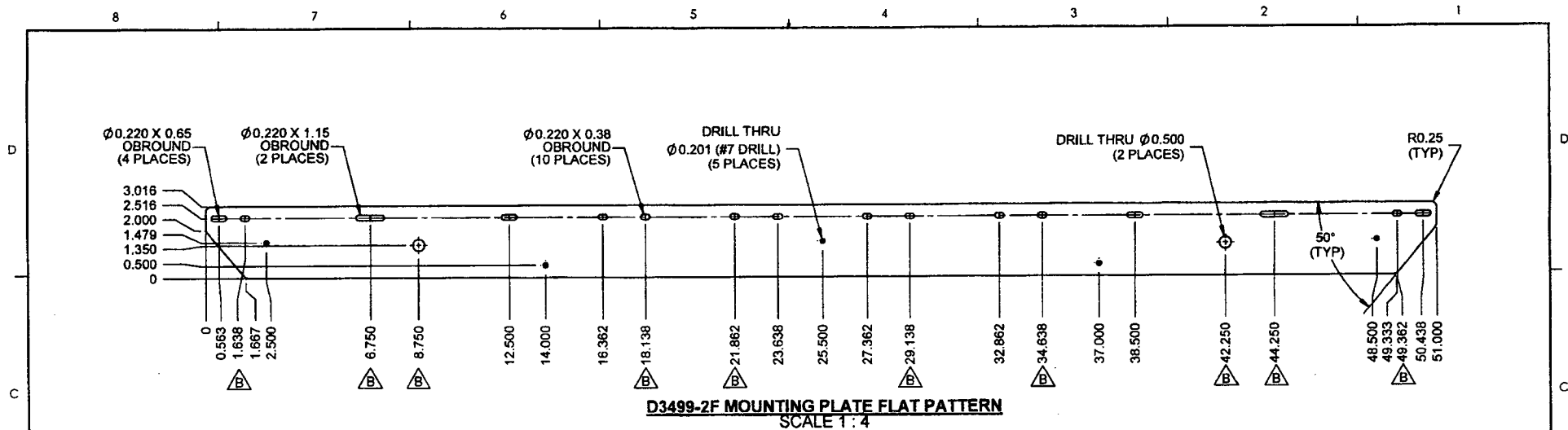
QTY -042	P/N	DESCRIPTION
X	D3499-042	CABLE GUARD ASSEMBLY
1	D3499-2	MOUNTING PLATE
1	D3499-3	PLASTIC GUARD
2	D3499-5	PLACARD
2	AN3C5A	BOLT
3	AN3C6A	BOLT
10	AN960C10L	WASHER
5	MS21043-3	NUT
5	NAS1515H3L	WASHER

**NOTES:**

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010

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NOTES:

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET (0.125 THICK)
PER AMS-QQ-A-250/11 OR AMS 4029 OR AMS 4027
(REF. DART SPEC. M8061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005. 4.1
POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

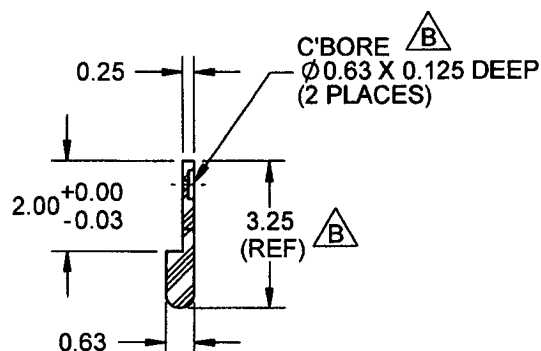
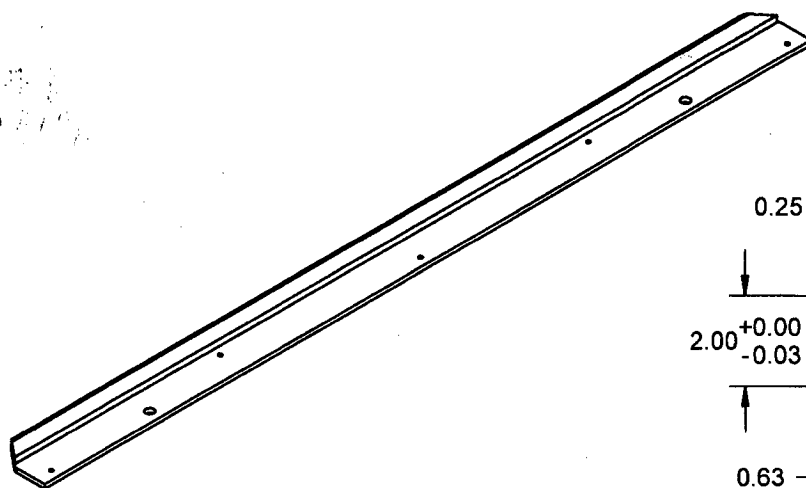
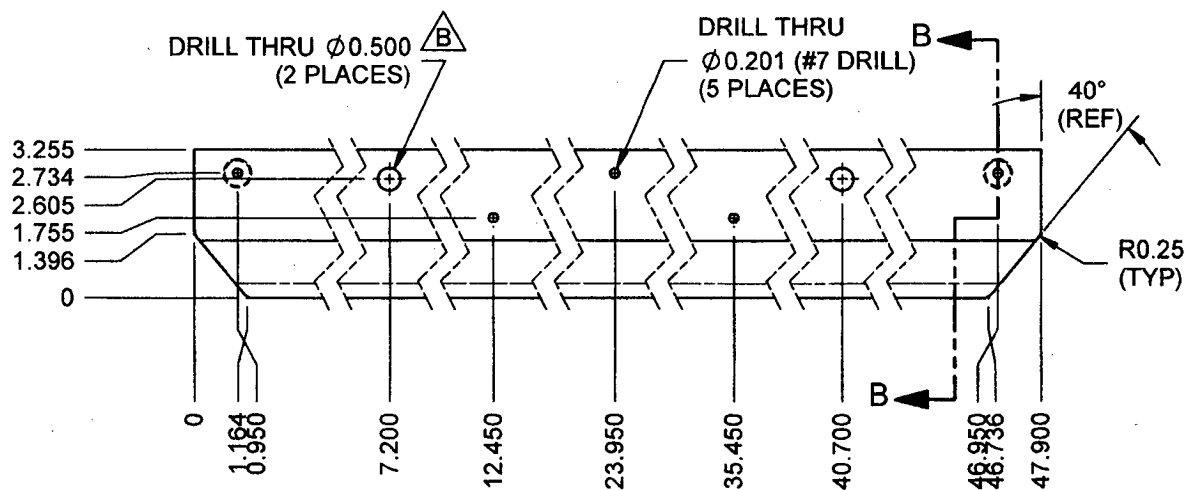
DESIGN	DRAWN BY	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED PH	APPROVED	DRAWING NO. D3499	REV. B SHEET 2 OF 4
DATE 06.08.15	TITLE CABLE GUARD	SCALE 1:2	

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DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3499	REV. B SHEET 3 OF 4
DATE 06.08.15		TITLE CABLE GUARD	SCALE 1:4

**SECTION B-B****D3499-3 CABLE GUARD****NOTES:**

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL (MUHMWB)
- 2) PART IS SYMMETRICAL AT CENTER LINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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